

Work Order ID 50770

July 22, 2009 7:16:50 AM



Page 1

Item ID: D2855

Accept

Revision ID: A

Item Name: Cap

Setup Start

Stop

Start Date: 7/23/09 Start Qty: 50.00

Required Date: 7/30/09 Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2855

Rev A

100

0.00



Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 1041 Cast per Dwg D2855 (Material Release Note Required)

28.07.27

110

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

Ensure Material Release Note is attached

8/9/16 (42)

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> 8/9/17
as per

counter
42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50770

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Page 2

Item ID: D2855

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Start Date: 7/23/09

Start Qty: 50.00

Required Date: 7/30/09

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1- Drill as per Dwg D2855 using DT8235 (2- Open holes to 19/64" (3- Deburr

0.00

0.00

M-H 09/09/22

46X

PTO ->

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

2) 8/2/23

46X

4

150



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

START TIME:

7:30 AM

FINISH TIME:

0.00

OVEN TEMPERATURE:

320°

⇒ 9/10/24

46X

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2855 PAR #: _____ Fault Category: Supplier/Aluminum Foundry NCR: Yes No DQA: [Signature] Date: 09/10/05
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: [Signature] Date: 09/10/05

NCR: <u>50770</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/9/05	#130	Found Qty +1 cap while drilling that only one side had the key ways casted correctly R.C. manufacturing error.	<u>[Signature]</u>	Scrap and Destroy Qty +1 inform supplier of issue <u>N/A</u>	<u>SAM</u> <u>09/09/23</u>	<u>S</u> <u>09/09/23</u>	<u>[Signature]</u>	<u>S</u> <u>09/09/23</u>

NOTE: Date & initial all entries

Work Order ID 50770

July 22, 2009 7:16:50 AM

Page 3

Item ID: D2855

Accept

Revision ID: A

Item Name: Cap

Start Date: 7/23/09

Start Qty: 50.00

Required Date: 7/30/09

Req'd Qty: 50.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Inserts as per Dwg D2855

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control



BR 09-09-24

(46)

M 09/09/25

(X46) /

2 502/01/25

counted
(X46) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 50770

July 22, 2009 7:16:50 AM



Page 4

Item ID: D2855

Accept



Setup Start



Revision ID: A

Stop



Item Name: Cap

Start Date: 7/23/09

Start Qty: 50.00



Cust Item ID:

Required Date: 7/30/09

Req'd Qty: 50.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: *FP-6*

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/25

(X45) 0

09/09/25

MF
09-09-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July 22, 2009 7:16:49 AM

Page 1

Work Order ID: 50770

Parent Item: D2855RevA

Parent Item Name: Cap

Comments:

Start Date: 7/23/09

Required Date: 7/30/09

Start Qty: 50.00

Required Qty: 50.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS7-1032-225		Purchased	No			100	Each	877.0000	100.0000			



INSERT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

11110768

877

100895

21

100896

102

102018

102

110118

52

111529

300

111581

300

D2855PRevA

Purchased

No

170

Each

0.0000

50.0000



Cap



x90 HJ 09/09/25

1094/16 (97)

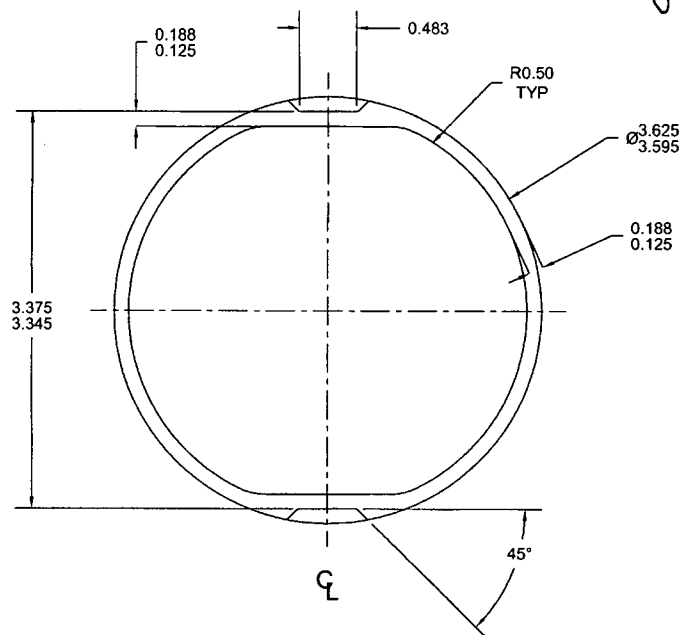
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

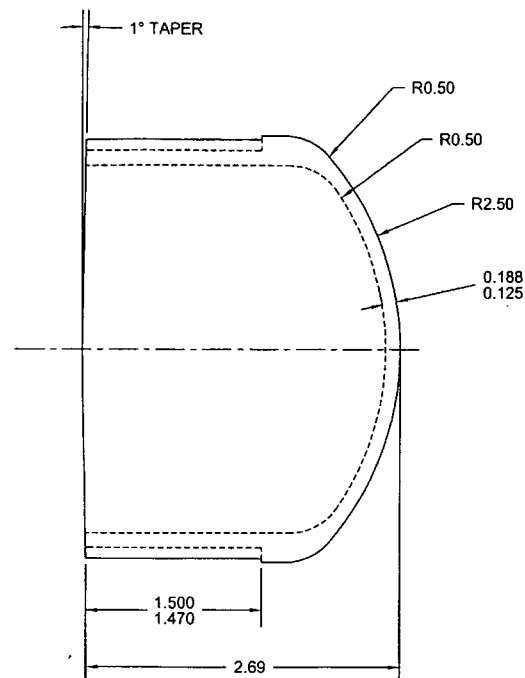
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O 50770



D2855C CASTING DETAIL



RELEASED
09/07/15 MJD

NOTES:

- 1) MATERIAL: CASTING ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.62 lbs

B	DRAWING UPDATED TO CURRENT STANDARDS. ADD D2855-3 & D2855C (ZN A4-1, A4-3)	RF	09.06.30
A	NEW ISSUE (WAS D2575 REV. E)	DS	96.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 1 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

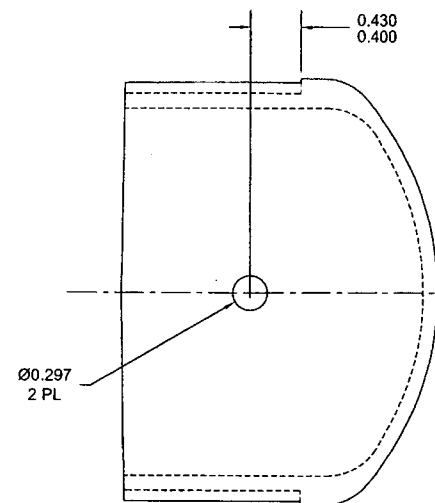
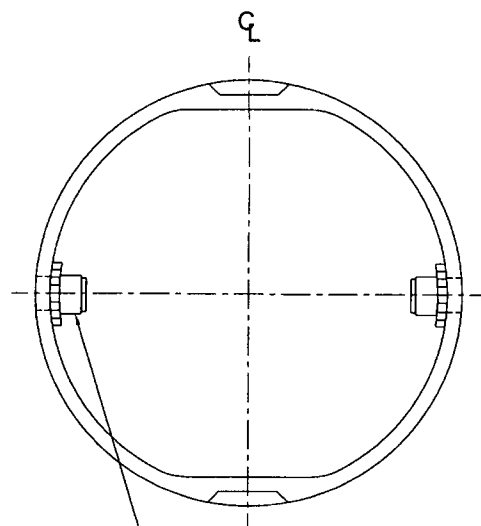
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855 CAP
(MAKE FROM D2855C CASTING)

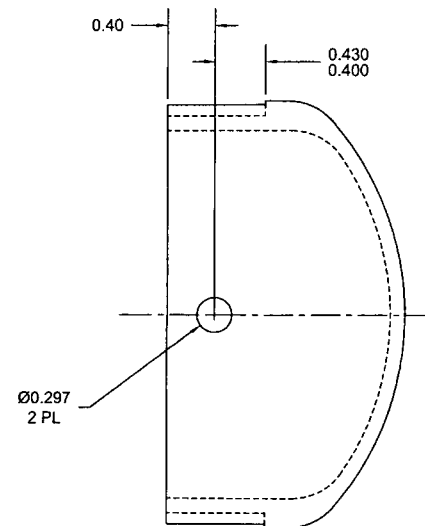
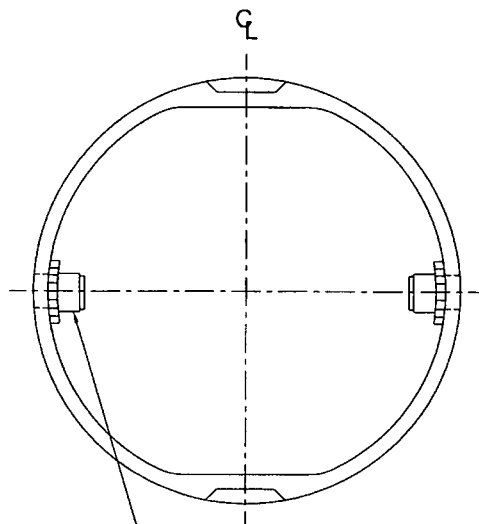
NOTES:

- 1) MATERIAL: MAKE FROM D2855C
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.63 lbs


DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	D2855	SHEET 2 OF 3
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	CAP	NTS
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RELEASED
2/15/15

50770



INSTALL ALS4-1032-225 (OR AKS7-1032-225, OR
ALS7-1032-225, OR AKS4-1032-225) INSERT ON
INSIDE OF CAP (AFTER POWDER COAT)
2 PL

D2855-3 CAP 
(MAKE FROM D2855C CASTING)

NOTES:

- 1) MATERIAL: MAKE FROM D2855C OR D2855
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. B
MFG APPR.	RF	D2855	SHEET 3 OF 3
APPROVED	IM	TITLE	SCALE
DE APPR.	SH	CAP	NTS
DATE	09.06.30	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
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RELEASED
09/07/51

50770



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10111

Purchase Order Date 7/22/09

PO Print Date 7/22/09

Page Number 1 of 1

Order From : VC-ALU001
ALUMINUM FOUNDRY & PATTERN WORKS LTD.
2225 CHEMIN ST. FRANCOIS
DORVAL, QC H9P 1K3
CA

Contact Name		Buyer	
Vendor Phone	514 683 9777	Requisition Nbr	
Vendor Fax	514 683 0375	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2855P A	Cap	7/22/09 Yes	50.00 Each		\$16.9000	\$845.0
New 47							
PO Total:							\$845.01

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

Change Nbr: 2

Change Date: 7/22/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Aluminum Foundry Ltd

2225 Chemin St. Francois

Dorval, Québec H9P 1K3

Tel: (514) 683-9777

Fax: (514) 683-0375

email: info@foundryafpw.com

Packing Slip

Packing Slip No.:

33132

Shipped Date:

Sep 14, 2009

Sold to:	Ship to:
DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7 Tel. (613) 632-5200 Fax (613) 632-5246	DART AEROSPACE 1270 ABERDEEN STREET HAWKSBURY, ONTARIO K6A 1K7
Order No.: 10111	
Shipped By: Fedex	
Tracking No.:	

Item No.	Unit	Description	Quantity
Z098046	Each	D2855 CAP REV.A <i>S. or / or / 17</i> Received by: Date:	✓ 47
Comment:			

7CERTIFICAT DE CONFORMITÉ
CERTIFICATE OF COMPLIANCE

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

714-716 CALAIS, DORVAL, QC H9P-2P3
TEL : (514) 631-1331 FAX: (514) 631-8448

Expédié à
Shipped

DART AEROSPACE

A.F. & P.W.Série no./Serial no.

1270 Aberdeen Street

Packing
Date: **14/09/2009** Slip No. **33132**

Hawksbury, ON, K6A 1K7

Votre No. Commande **10111**
Your order No.

Ceci est pour certifié que le materiel liste ci-dessous est selon les specifications du bon d'achat ci-haut, et que les documents en evidence des rapports et certificats di détaillante sont en filiere dans notre bureau.

This is to certify that the material listed below is according to your specifications on above P.O. and that documentary evidence of the tests or release certificates from the original supplier are on file in this office.

Quantite Quantity	Description	Notre No. Our No.	Specifications	Note d'autorisation Incoming Release note
47pcs	D 2855 CAP	Z098046	A356.2 <i>S</i> <i>08/01/07</i>	ingot#0853476
Analyse Analysis (as in ingot)				
(Si)	7.17%	(Al)	balance	
(Fe)	0.087%			
(Cu)	0.0024%			
(Mn)	0.0017%			
(Mg)	0.37%			
(Zn)	<0.001%			
(Ti)	0.16%			
Donne Yield :	Résistance a la tension : Tensile Strength :	Allongement par pouce carré : P.S.I. Elongation : %		

Pour et au nom de
For and on behalf of :

FONDERIE D'ALUMINIUM ET MODELERIE (1988) LTEE
ALUMINUM FOUNDRY & PATTERN WORKS (1988) LTD

Dept/Dep :

Par/Per :

Coc-100